

Work Order ID 144734

Friday, April 22, 2016 4:00:02 PM

144734

Page 1

Item ID: D4773-041

Accept

N900040100Setup Start ***NS1***

Revision ID:

Stop ***NS2***

Item Name: Wearplate Assembly

Start Date: 5/2/2016 Start Qty: 2.00

Required Date: 5/9/2016 Req'd Qty: 2.00

Cust Item ID:

Customer:

Reference:

Approvals:

Process Plan: *gm/mk*Date: *16/04/22* Tooling:

Date:

QC:

Date: SPC (Y/N):

Date:

Run Start ***NR1***Stop ***NR2***Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run Hours

Tool ID

Tool #

Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

Draw Nbr

Revision Nbr

D4773

C

120

0.00

120

Large Fab

Large Fab

Memo

3.12

1- Weld hardcoat on bars as per dwg

A/R 2059b hardcoat Batch#: *127737*

2- Weld bar to wearplate as per dwg

A/R s.s. rod Batch #: *128014*

3- Weld shim as per dwg

A/R s.s. rod Batch #: *126014*

4- Transfer drill drain holes as per dwg

130

QC9- Inspect visual per QSI004- Fusion Welds

0.00

130

QC

Quality Control

Memo

0.00

④ 16-05-11 PD

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS <table style="width: 100%; border: none;"> <tr> <td style="border: none;">Skid-tube ☐</td> <td style="border: none;">Cross tube ☐</td> <td style="border: none;">Water Jet ☐</td> <td style="border: none;">Engineering ☐</td> </tr> <tr> <td style="border: none;">Machining ☐</td> <td style="border: none;">Small Fab ☐</td> <td style="border: none;">Prod. Eng. Coord. ☐</td> <td style="border: none;">Quality ☐</td> </tr> <tr> <td style="border: none;">Thermoforming ☐</td> <td style="border: none;">Finishing ☐</td> <td style="border: none;">Rec/Store/Packaging ☐</td> <td style="border: none;">Other ☐</td> </tr> <tr> <td style="border: none;">Large Fab ☐</td> <td style="border: none;">Composite ☐</td> <td style="border: none;">Supplier ☐</td> <td style="border: none;"></td> </tr> </table>						Skid-tube ☐	Cross tube ☐	Water Jet ☐	Engineering ☐	Machining ☐	Small Fab ☐	Prod. Eng. Coord. ☐	Quality ☐	Thermoforming ☐	Finishing ☐	Rec/Store/Packaging ☐	Other ☐	Large Fab ☐	Composite ☐	Supplier ☐	
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Description Work Order Deviation				Disposition				Completed By Lead hand / Supervisor Approval Verification QC / QA Coordinator Approval																	
Root Cause		FAULT CATEGORY																							
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Item Name: Wearplate Assembly

Start Date: 5/2/2016 Start Qty: 2.00

2

Cust Item ID:

Required Date: 5/9/2016 Req'd Qty: 2.00

2

Customer:

Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____

Run Start ***NR1***

QC: _____ Date: _____ SPC (Y/N): _____ Date: _____

Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
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140

QC5- Inspect part completeness to step on W/O

0.00

140

QC

Memo

0.04

Quality Control

(4) 16-DS-11 PD

150

0.00

150

SprayPaint

Memo

0.00

Spray Painting

1- Apply Rockguard on entire concave surface as per dwg

A/R Rockguard Batch: 134681

2- Indicate FWD direction as shown using white paint marker(SEE NOTE 8)

4

DAS
41
9-89

16-5-12

160

QC5- Inspect part completeness to step on W/O

0.00

160

QC

Memo

0.04

Quality Control

(4)

DAS
38
9-89

MAY 11 2016

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

QA Closed: _____ Date: _____

Work Order update only ☐

Work Order: _____ Part No. _____ NCR No. _____		DISPOSITION Rework ☐ Scrap ☐ Use-as-is ☐ Suspected Unapproved ☐		AGAINST DEPARTMENT/PROCESS Skid-tube ☐ Machining ☐ Thermoforming ☐ Large Fab ☐ Cross tube ☐ Small Fab ☐ Finishing ☐ Composite ☐ Water Jet ☐ Prod. Eng. Coord. ☐ Rec/Store/Packaging ☐ Supplier ☐ Engineering ☐ Quality ☐ Other ☐					
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								Lead hand / Supervisor Approval Verification	
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Item Name: Wearplate Assembly
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Reference:

Approvals: Process Plan: _____ Date: _____ Tooling: _____ Date: _____ Run Start ***NR1***
QC: _____ Date: _____ SPC (Y/N): _____ Date: _____ Stop ***NR2***

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
170	Identify as per dwg & Stock Location: <i>5/6/12</i>	0.00							
170									
Packaging	Memo	0.02							DAS 0 8-89
Packaging									
180	QC21- Final Inspection - Work Order Release	0.00							
180									
QC	Memo	0.20							MCS MAY 17 2016
Quality Control									

MAY 16 2016

MCS

DQA: _____ Date: _____



WORK ORDER NON-CONFORMANCE / UPDATE

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Work Order update only ☐

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Picklist Print

Friday, April 22, 2016 4:00:08 PM

Page 1

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144734

Parent Item: D4773-041

D4773-041

Parent Item Name: Wearplate Assembly

Start Date: 5/2/2016

Required Date: 5/9/2016

Start Qty: 2.00

Required Qty: 2.00

Comments:

IPP REV:A 13.03.26 NEW ISSUE DD VERF:JLM
REV:B 13.11.13 DWG REV.B DD VERF:JLM
13.11.13 DWG REV.pc4 DD VERF:JLM

IPP
IPP REV:B

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
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D4682-9

Manufactured

No

Each

18.0000

2

D4682-9

16-05-11

Wearplate Shim

Location

Loc Qty

Loc Code

WA002

18

141356

18

Each

4.0000

4

D4770-7

Manufactured

No

D4770-7

16-05-05

Bar

Location

Loc Qty

Loc Code

WA001

4

133955

4

Each

0.0000

2

D4773-1

Manufactured

No

D4773-1

Wearplate

144816

4

16-05-10

JBL

DQA: _____ Date: _____



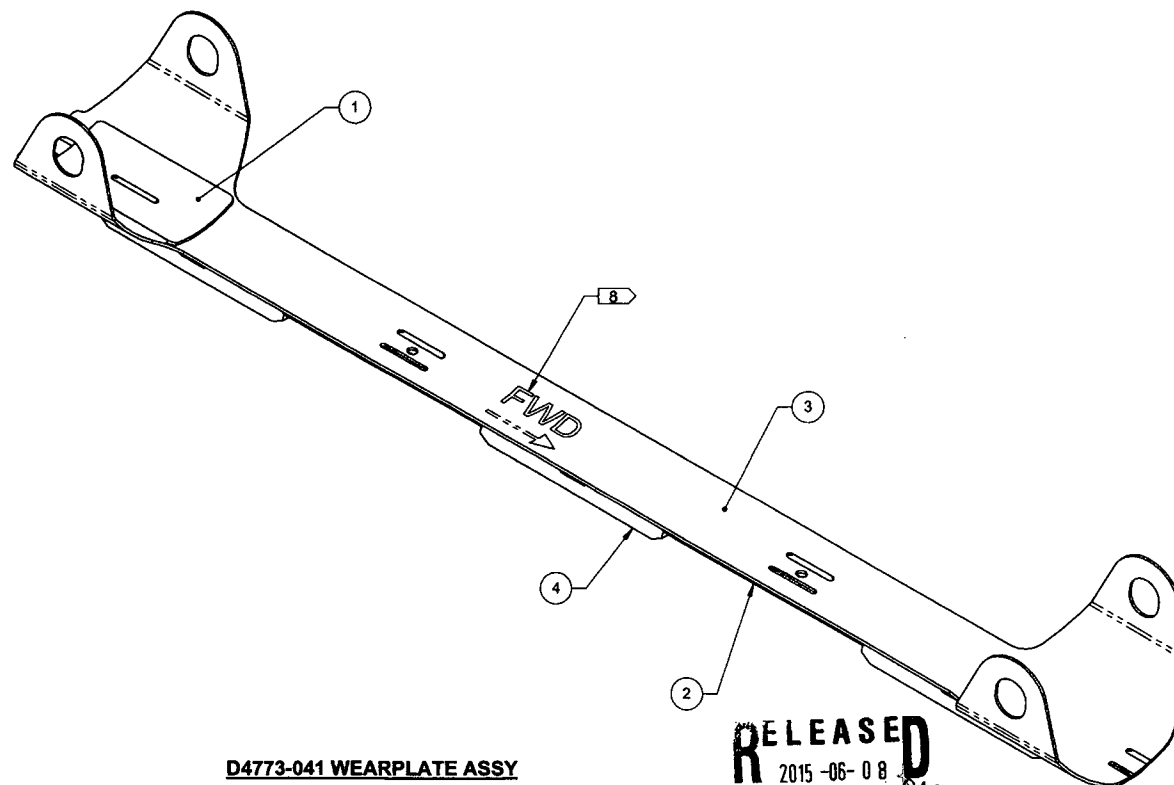
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ITEM	QTY -041	P/N	DESCRIPTION
	X	D4773-041	WEARPLATE ASSY
1	1	D4682-9	WEARPLATE SHIM
2	2	D4770-7	BAR
3	1	D4773-1	WEARPLATE
4	A/R	2059B	HARDCOAT



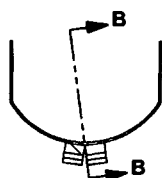
D4773-041 WEARPLATE ASSY

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2015-06-08
EN 15-57

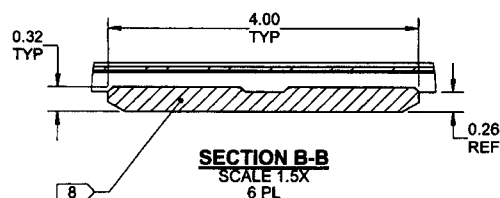
C	ADD FWD DIRECTION INDICATION, WEARPLATE FORMING METHOD MODIFIED TO ACCOMMODATE MATERIAL SPRING BACK, MINOR DIMENSIONAL CHANGES. TEXTURED COATING WAS ROCKGUARD, D4770-7 WAS D4770-1, ADD SHT 4	AP	15.04.01
B	D4682-9 WAS D4682-3. THRU HOLES NOW SLOTS. VARIOUS DIMENSIONAL CHANGES. UPDATED PART WEIGHTS	DB	13.08.08
A	NEW ISSUE	AP	13.02.13
REV.	DESCRIPTION	BY	DATE
DESIGN	AJS	DART AEROSPACE USA, INC. KENT, WA	
DRAWN	AP		
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D4773	SHEET 1 OF 4
APPROVED	HS	TITLE	SCALE
DE APPR.	DS	WEARPLATE ASSY	NTS
DATE	15.04.01	COPYRIGHT © 2013 BY DART AEROSPACE USA, INC. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS CONDITION THAT IT IS NOT TO BE USED FOR ANY PURPOSE OR COPIED OR COMMUNICATED TO ANY OTHER PERSON WITHOUT WRITTEN PERMISSION FROM DART AEROSPACE USA, INC.	

NOTES:

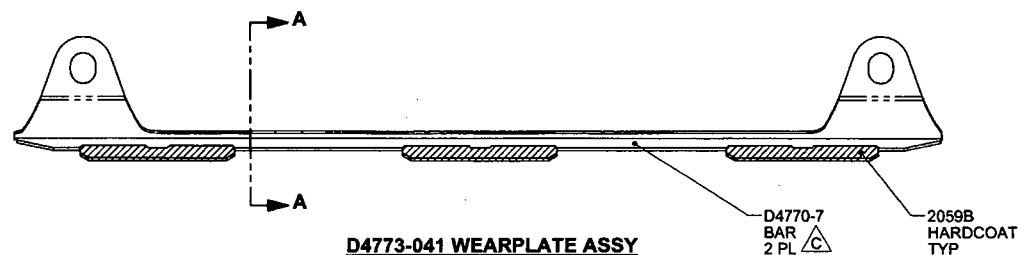
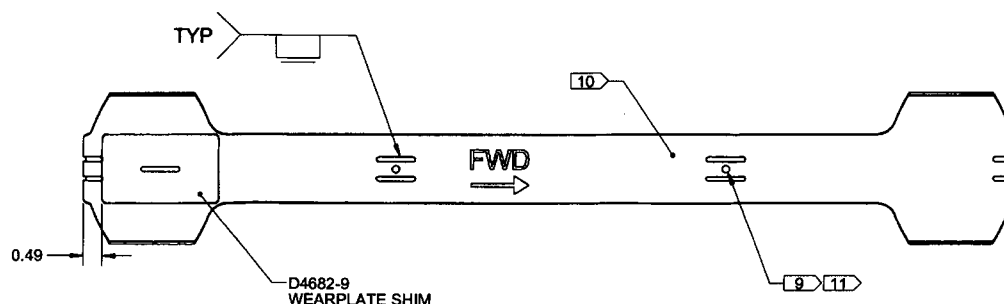
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 3.58 lbs
- 8) INDICATE FWD DIRECTION IN LOCATION SHOWN USING WHITE PAINT MARKER



SECTION A-A



SECTION B-B
SCALE 1.5X
6 PL



NOTES:

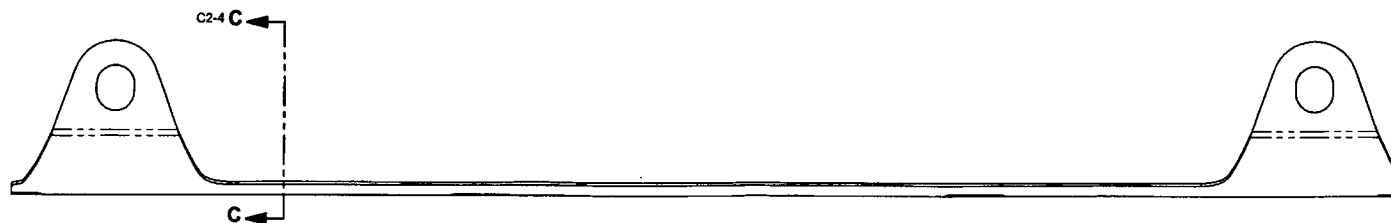
- 1) MATERIAL: N/A
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: IDENTIFY PER QSI 044 METHOD 6.1
- 7) WEIGHT: 3.56 lbs
- 8) WELDING: PER QSI 004. 2059B HARDCOAT WELD, 0.32 THICK X 0.50 WIDE, FLUSH WITH D4770-7 BAR ON LATERAL SURFACES, 6PL
- 9) TRANSFER DRILL $\varnothing 0.188$ HOLE FROM D4773-1 WEARPLATE TO D4770-7 BAR
- 10) COAT ENTIRE TOP (CONCAVE) SURFACE WITH LAYER OF TEXTURED COATING, 0.020 - 0.040 THICK, PER QSI 005.
- 11) OPEN UP DRAIN HOLE IF NECESSARY TO $\varnothing 0.188$ AFTER APPLYING TEXTURED COATING

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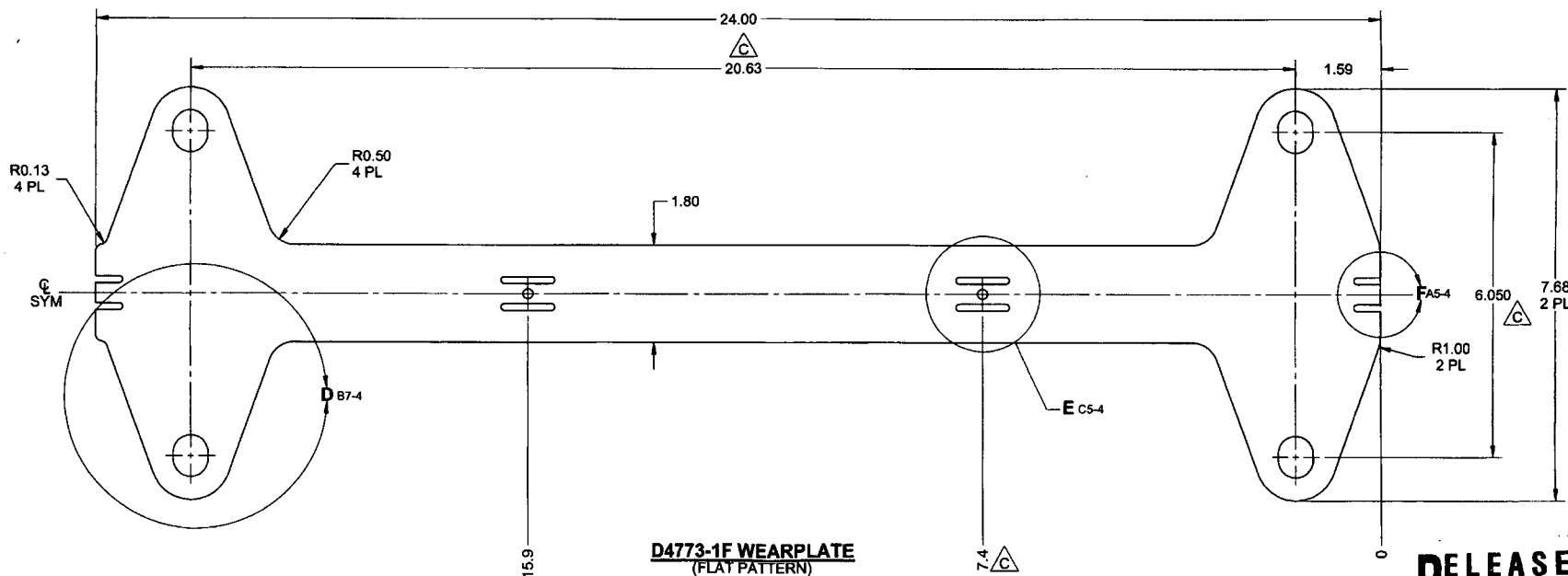
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DESIGN	AJS	DART AEROSPACE USA, INC.	
DRAWN	AP	KENT, WA	
CHECKED	AJS	DRAWING NO.	REV. C
MFG. APPR.	DD	D4773	SHEET 2 OF 4
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8 7 6 5 4 3 2 1



D4773-1 WEARPLATE
(MADE FROM D4773-1F)



D4773-1F WEARPLATE
(FLAT PATTERN)

NOTES:

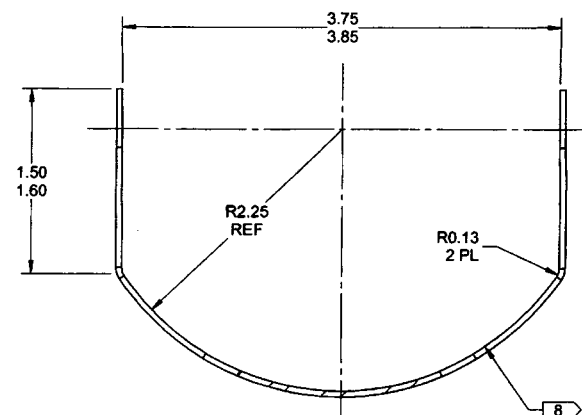
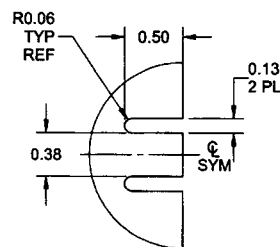
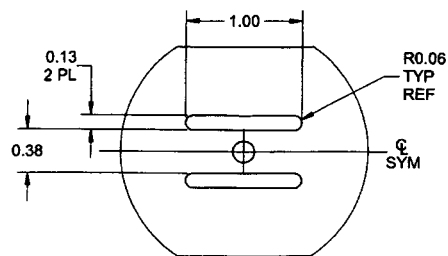
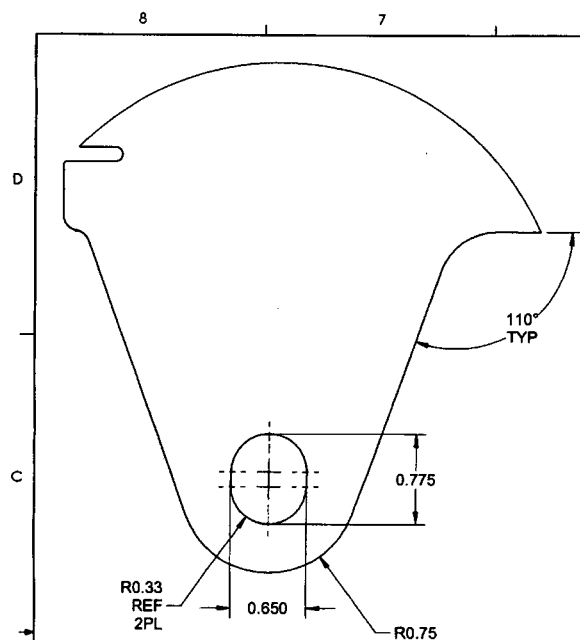
- 1) MATERIAL: AISI 304/316 STAINLESS STEEL PER MIL-S-5059 OR AMS 5513 OR 5524 OR ASTM A240 OR ASME SA240 18 GAUGE 0.050 THICK, REF DART SPEC. M304S18GA
- 2) FINISH: NONE
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 0.94 lbs
- 8) FORM USING R1.9 DIE

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MFG. APPR.	DD	D4773	SHEET 3 OF 4
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8 7 6 5 4 3 2 1



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MFG. APPR.	DD	D4773	SHEET 4 OF 4
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